

Work Order ID 69595

Thursday, May 12, 2011 3:23:59 PM



Page 1

Item ID: D2858-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 5/12/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-05-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2858

Rev B

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks 5.850

" Note: 1 Blank Makes 3 Parts

0.00

0.00

OK/FK 11/08/11

824

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA941

FOLIO REV: *4A*

DWG REV: *B*

2-Deburr any rough edges

0.00

0.00

SL 11/08/22

24

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SL 11/08/22

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 11/08/23

24

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

24 X M 11/08/24

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 117745

32001

3:45

4:15

24 X M 11/08/24

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24 BL 11-8-24

170

Identify as per dwg & Stock Location: ST24

0.00



Packaging

Memo

0.00

Packaging

SP 24x SP 11-08-25

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

CL11108125

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:24:06 PM

Page 1

Work Order ID: 69595



Parent Item: D2858-1



Parent Item Name: Hinge Bracket

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	12.9418	0.163	4.117895			



6061-T6 Bar 1.50 x 1.25



FR. 11/08/11

Location

Loc Qty

Loc Code

MAT004

12.9418

107461

0.9

- 110936

12.0418

- 118071

~~3.04~~

3.04

995

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69595
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	.172	✓		Vern JLG	
Ø0.400	+0.006/-0.001	.400	✓		"	
R0.125	+/-0.010	.125	✓		R-G	
0.328	+/-0.010	.327	✓		"	
0.820	+/-0.005	.820	✓		"	
1.476	+/-0.010	1.475	✓		"	
0.342	+/-0.010	.342	✓		"	
0.875	+/-0.005	.875	✓		"	
1.56	+/-0.030	1.562	✓		"	
0.147	+/-0.010	.150	✓		"	
0.717	+/-0.010	.725	✓		H-G	
0.697	+/-0.010	.694	✓		"	
0.229	+/-0.010	.230	✓		"	
R0.125	+/-0.010	.125	✓		R-G	
R0.063	+/-0.010	.063	✓		R-G	
0.063	+/-0.010	.065	✓		"	
0.126	+/-0.010	.127	✓		"	
0.630	+/-0.010	.632	✓		"	
R0.354	+/-0.010	.354	✓		"	
0.965	+/-0.010	.968	✓		"	
Ø0.166	+0.005/-0.001	.167	✓		"	
R0.125	+/-0.010	.125	✓		R-G	
32.7°	+/-0.5°	32.7	✓		"	

Measured by:	JL	Audited by:	B.A	Prototype Approval:	N/A
Date:	11-08-22	Date:	11/08/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	

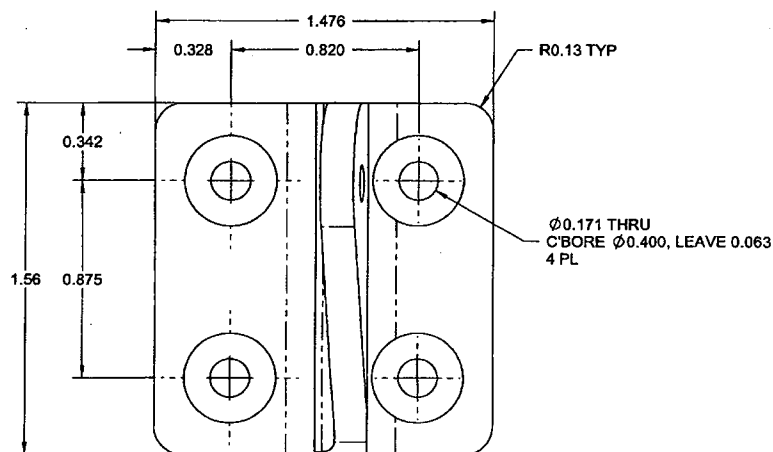
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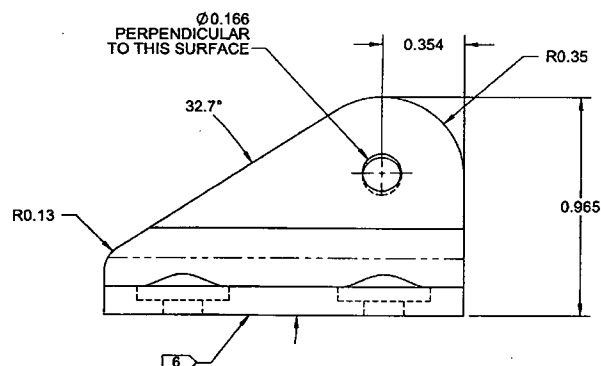
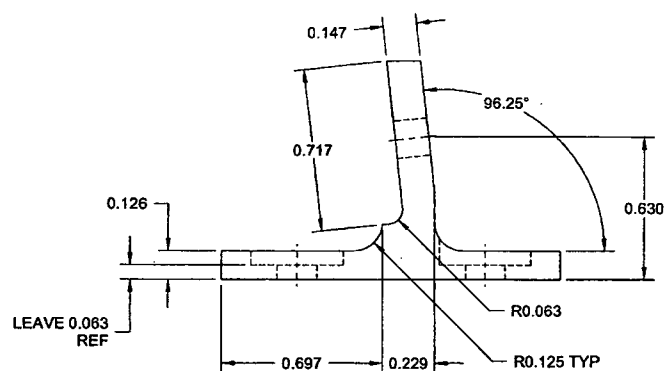
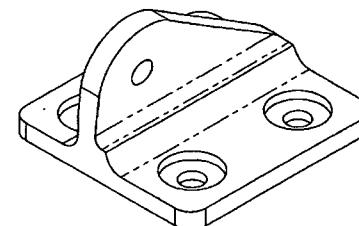
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69595

PL 11-05-12



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD, REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1, A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KG	DART AEROSPACE LTD	
DRAWN	<i>kg</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>kg</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>kg</i>	D2858	SHEET 1 OF 2
APPROVED	<i>kg</i>	TITLE	SCALE
DE APPR.	<i>kg</i>	HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD	
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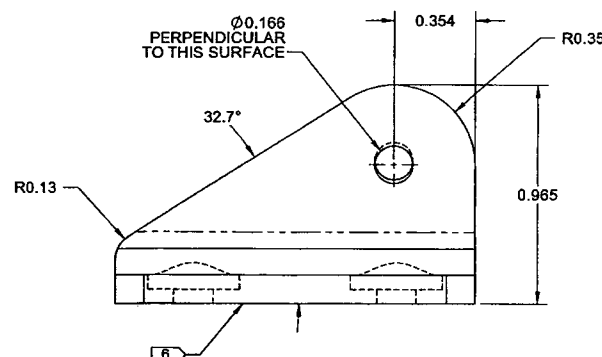
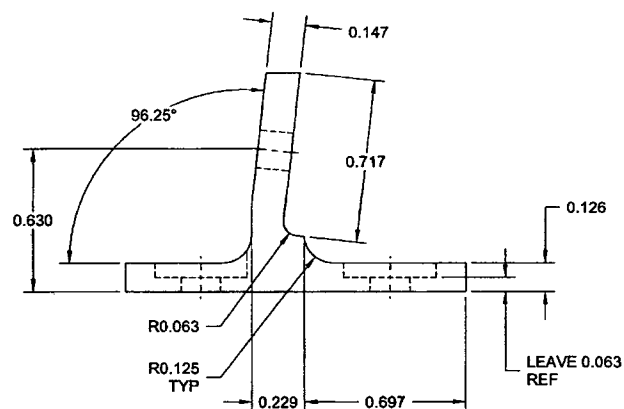
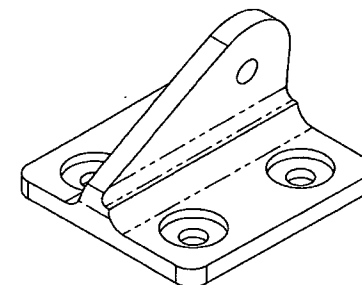
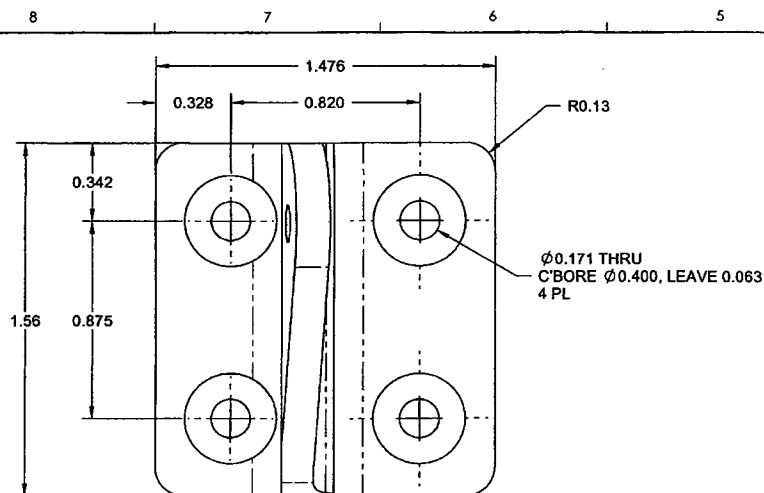
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NOTE: Date & initial all entries



al64595

RELEASED
2010-11-26

D2858-2 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-2" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2858	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD	
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